

1.B11-3-10

Work Order ID 67191

Thursday, March 10, 2011 7:21:50 AM



Page 2

Item ID: D4207-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Window Retainer

Start Date: 3/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspector to PAD



QC

Memo

0.00 Day only

Quality Control

8/10/10

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-370

135

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/3/10 SP

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Page 3

Item ID: D4207-1

Accept

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Item Name: Window Retainer

Start Date: 3/10/2011 Start Qty: 1.00

Required Date: 3/10/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/3/10

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Roberts

11.03.10

POSITIVE RECALL

EFFECTIVE 11.03.10 AUTH

RELEASED _____ DATE _____

Picklist Print

Thursday, March 10, 2011 7:21:47 AM

Page 1

Work Order ID: 67191

Parent Item: D4207-1

Parent Item Name: Window Retainer




Start Date: 3/10/2011

Required Date: 3/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	174.6295	1.148	1.208421			
													
2024-T3 .040 sheet													



B11-3-10

Location

Loc Qty

Loc Code

MAT

11.8

114415

11.8

MAT22

162.8295

110305

12.5

111786

7.66

112291

14.25

112331

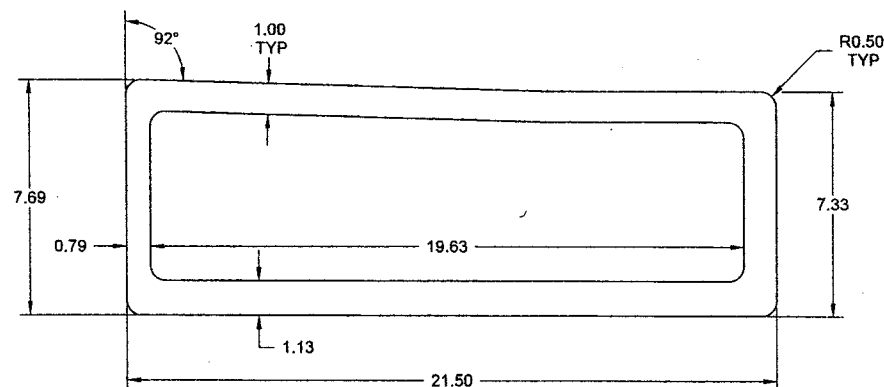
52

113162

76.4195

112291

①



D4207-1 WINDOW RETAINER
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-14)

PRELIMINARY ISSUE

10.11.22

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

w/o 67191

PA2	ADD MLEXS.063-9034-08 TO D4207-3 NOTES (ZN A8-2)	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA2
MFG. APPR.	<i>[Signature]</i>	D4207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

